

Work Order ID 65156

Thursday, January 06, 2011 3:32:38 PM



Page 1

Item ID: D3436-043

Accept



Setup Start



Revision ID:

Item Name: Step LH

Stop



Start Date: 1/6/2011

Start Qty: 2.00

1.00



Required Date: 1/14/2011

Req'd Qty: 2.00

1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

11-01-7

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3436

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and
Dwg D3436Dwg Rev: A Qty Part Number Description
Batch ☐ A/RN/A 4130 Welding Rod M19317 ☐ Weld
left step D3436-7 using welding Jig DT

11.09.06

1

110

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1- Slit part D3436-041 on bandsaw as per Dwg D3436
deburr

☐ 2-

11.09.06

1

120

QC9- Inspect visual per QSI004- Fusion Welds\

0.00



QC

Memo

0.00

Quality Control

1 2 0 BEU/09/06

Thursday, January 06, 2011 3:32:38 PM

Item ID: D3436-043

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Setup Start[illegible]

Stop

Required Date: 1/14/2011 **Req'd Qty:** 2.00

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

**Insp.
Stamp**

0.00

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QC

Memo

0.00

Quality Control

0.00 $\delta u_{\text{orb}}/u_{\text{orb}}$

④

LN

0.00

Powdercoat

Powder Coating

Memo

0.00

Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4

START TIME:

OVEN TEMPERATURE:

FINISH TIME: 10

Wing Walk batch:

anti-skid paint as per Dwg D3436 and QS
11-45
RATURE: 40001
12-15
ch: M118313

IX ~~Ø~~ M 11/09/06
LH

0.00

[illegible]

QC

Quality Control

Memo

0.00

1xh4 *M* 11/09/06

Work Order ID 65156

Thursday, January 06, 2011 3:32:38 PM



Page 3

Item ID: D3436-043

Accept



Setup Start



Revision ID:

Item Name: Step LH

Stop



Start Date: 1/6/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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155

0.00



Small Fab

Memo

0.00

Small Fab

Bond D3436-9 pads as per dwg and QSI 015

EP 11/09/07 ①

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

84109107

(X)

LH

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging






11/9/7



Work Order ID 65156


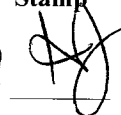
Thursday, January 06, 2011 3:32:38 PM



Page 4

Item ID: D3436-043 Accept  Setup Start 
Revision ID: Stop 
Item Name: Step LH
Start Date: 1/6/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 1/14/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/9/7	

ME
11-09-07





Thursday, January 06, 2011 3:32:42 PM

Page 2

[illegible][illegible]**Required Date:** 1/14/2011

Required Qty: 2.00

Comments: IPP .A 05.05.11 New Issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3436-1  Clamp		Manufactured	No			100	Each	49.0000	1	2		11.09.06	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				49					
					17679			49					
D3436-3  Left Step		Manufactured	No			100	Each	4.0000	1	2		11.09.06	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				4					
					56841			4					
D3436-5  Bushing		Manufactured	No			100	Each	19.0000	4	8		11.09.06	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA	364063			19					
					56893			19					
D3436-9  Pad		Manufactured	No			100	Each	12.0000	2	4		5/09/07	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST056				12					
					56830			6					
					64069			6					

Picklist Print

Thursday, January 06, 2011 3:32:42 PM

Page 2

Work Order ID: 65156



Parent Item: D3436-043



Parent Item Name: Step LH

Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

D3436-7

Manufactured No

160

Each

40.0000

1

2



11.09.06

Cap

Location

Loc Qty

Loc Code

WA

40

56836

40

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

SHOP COPY

RETURN TO
ENGINEERING

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:4
A	05.04.28	NEW ISSUE	

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 65156BL11-01-7BOND WITH CONTACT
CEMENT PER
MANUFACTURER'S
SPECIFICATION
(2 PLACES)

D3436-9 PAD (2)

5
ANTI-SKID
PAINT

5.00

0.50

D3436-041
CLAMPD3436-043, LH STEP
D3436-044, RH STEP
(NOT SHOWN)3
Ø 2.38
(REF)D3436-1
CLAMP (1)D3436-5
BUSHING (4)CUT AFTER
WELDING0.190
0.63
(TYP)D3436-3
LEFT STEP (1)
OR
D3436-4
RIGHT STEP (1)
(NOT SHOWN)0.13
D3436-7
CAP (1)

45°

6.00

0.10

VIEW A-A

(4 PLACES)

0.13
0.13

16°

0.25

1.75
(REF)

WELDING

RELEASED

05.05.27 *[Signature]***NOTES:**

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

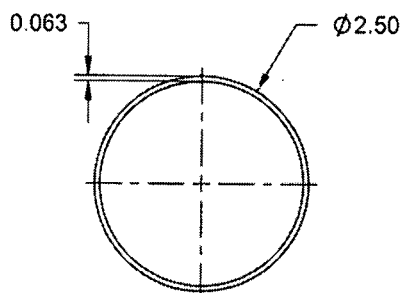
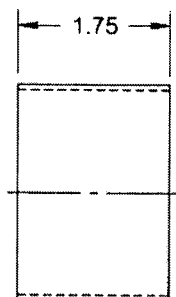
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



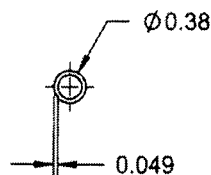
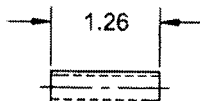
DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 2 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2

w/o 65154



D3436-1 CLAMP

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



D3436-5 BUSHING

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

RELEASED

05-05-27 *[Signature]*

D3436-1/-5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

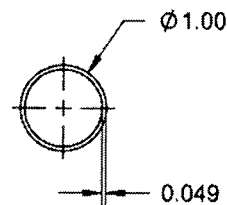
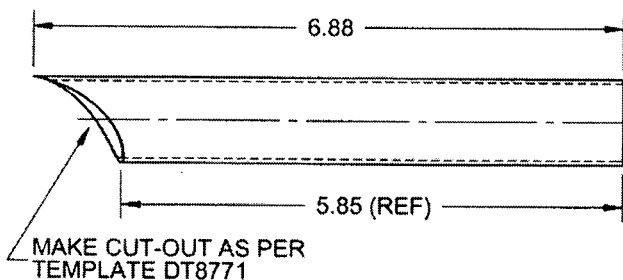
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3436	REV. A SHEET 3 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2

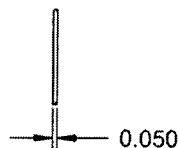
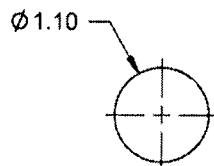
W/O 05/56



D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

D3436-3/ -7, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED

05-05-27 H

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

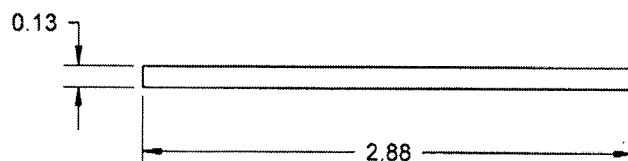
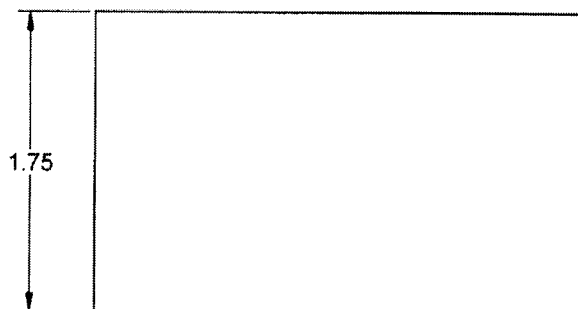
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED //	APPROVED //	DRAWING NO. D3436	REV. A SHEET 4 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:1

w/665156



RELEASED

05-05-27

D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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